



# MIROTONE

Leading the way in coating systems since 1938

## Data Sheet

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## MIROTHANE® PU 5600 Pigmented Undercoat



### Important Information

Mirotone only warrants the quality of the product in the can. It is your responsibility as the user, before application, to ensure that the coating system meets your requirement and is fit for the intended purpose.

### Product Description

MIROTHANE PU 5600 is a user friendly, two pack pigmented, polyurethane undercoat which provides an excellent base for polyurethane topcoats. Fast dry and high build ensures high productivity for the user. A special design feature of this product is its compatibility with MIROTHANE PU 5650 pigmented topcoat. The ability to add your excess topcoat into the undercoat not only improves coverage but also reduces cost and waste. This product is designed for interior use only and is suitable for top coating with a large range of Mirotone pigmented topcoats.

### Features & Benefits

<b>Universal:</b>	MIROTHANE PU 5600 can be overcoated with MIROTHANE PU 5605, 5650 and MIROBILD AC 3750 coatings.
<b>Tinted Undercoat:</b>	MIROTHANE PU 5600 comes in a standard range of tinted undercoat colours which results in improved opacity and less coats being required. Ultimately saving cost and improving productivity.
<b>Minimum Waste:</b>	Use up excess MIROTHANE PU 5650 pigmented topcoat by adding it to MIROTHANE PU 5600 undercoat to create your own tinted undercoat.
<b>High Build:</b>	Enhances the finished appearance of the topcoat, it can be applied directly over MDF to seal the fibres.
<b>Excellent Flow:</b>	Provides an excellent base requiring less sanding, resulting in a smooth level finish.
<b>Easy to Sand:</b>	Results in minimal sanding time, less coating waste and low sandpaper consumption.

### Typical Applications

- Commercial Joinery / Wall Panelling
- Dining & Bedroom Suites
- High Rise Office & Hotel Fittings
- Kitchen & Bathroom Cabinets

### Product Properties

<b>Colour</b>	White
<b>Tinted Undercoat</b>	MIROTHANE PU 5650 topcoat may be added to MIROTHANE PU 5600 to tint the undercoat. See the "Tinted Undercoat" section for mixing instructions.
<b>Coloured Undercoat</b>	If a pre-coloured undercoat is required, Mirotone can supply a range of coloured undercoats to suit your requirements. See the "Tinted Undercoat" section for colour availability.
<b>Gloss Level</b>	Undercoat
<b>Vertical Hang-Up</b>	Good
<b>Solvent Resistance</b>	Excellent
<b>Sandability</b>	Excellent
<b>Build</b>	Good
<b>Water Resistance</b>	Excellent
<b>Hardness</b>	Excellent after 24 hours
<b>Levelling &amp; Flow</b>	Good - Self Levelling
<b>Sink Back</b>	Minimal

### Application Methods

<b>Suction Gun</b>	Use 1.5 to 2mm (59 - 79 thou) orifice with 350-400kpa (50-55 psi).
<b>Pressure Pot</b>	Use 1.5 to 2mm (59 - 79 thou) orifice with pressure pot air-cap. Gun pressure 350-400kpa (50-55 psi) and a pot pressure of 45kpa (6 psi) max.
<b>Airless Spray</b>	Use 0.23 to 0.33mm (9 - 13 thou) orifice, 15cm fan (dependent on job) with regulated pump pressure of 350-400kpa (50-55 psi).
<b>Air Mix Guns</b>	Settings similar to airless spray with the air-assisted regulator pressure at 70-90kpa (10-15psi).

Mirotone recommends a range of spray equipment. Please contact your Mirotone representative for information on equipment for your application.

### Mixing Ratio / Thinning Reduction Rate / Pot Life

MIROTHANE PU High Solids (HS) Part B's	Mixing Ratio	Cure Speed	Low Yellowing	Solids	Flexibility	Thinning	Pot Life @ 25°C
All new High Solids (HS) PU Hardeners have equal strength and may be blended to achieve intermediate rates of cure without changing the specified mixing ratio.							
MIROTHANE PU 5715 Ultra Fast Cure High Solids Hardener	4A: 1B	Ultra Fast	••	High	OK	55%	0.5 - 1 hour
MIROTHANE PU 5718 Fast Cure High Solids	4A: 1B	Very Fast	•	High	Very	50%	1.5 - 2 hours

Hardener					Good		
MIROTHANE PU 5728 Fast Cure High Solids Hardener	4A: 1B	Fast	••	High	Good	60%	1 - 1.5 hours
MIROTHANE PU 5735 Fast-Medium Cure High Solids Hardener	4A: 1B	Fast-Medium	•••	High	Very Good	55%	1.5 - 2 hours
<b>MIROTHANE PU "Ready For Use" (RFU) Part B's</b>							
	<b>Mixing Ratio</b>	<b>Cure Speed</b>	<b>Low Yellowing</b>	<b>Solids</b>	<b>Flexibility</b>	<b>Thinning</b>	<b>Pot Life @ 25°C</b>
MIROTHANE PU 5747 Hardener	2A: 1B	Medium	••	Low - RFU	Good	15-25%	1.5 - 2 hours
MIROTHANE PU 5780 Hardener	2A: 1B	Medium/Slow	•••	Low - RFU	Excellent	15-25%	2 hours
<b>Other MIROTHANE PU Hardeners</b>							
	<b>Mixing Ratio</b>	<b>Cure Speed</b>	<b>Low Yellowing</b>	<b>Solids</b>	<b>Flexibility</b>	<b>Thinning</b>	<b>Pot Life @ 25°C</b>
MIROTHANE PU 5710 Hardener	5A: 1B	Slow	•••	High	Excellent	15-25%	2 hours

**Low Yellowing Rating Guide**

••• Non-Yellowing      •• Low Yellowing      • Will Yellow Slightly      • Will Yellow

**Mixing:** Mix Part A and Part B together before thinning. Mix thoroughly.

**Thinning:** The thinning rates above are based upon thinning with MIROSOL 1217 Fast Aromatic Free Thinner to 25 seconds BS4 viscosity at 25°C. The % thinning rate is based on Part A and Part B total mixed volume.

**Pot life** varies with ambient temperature and the quantity mixed. Pot life is longer at lower temperatures and shorter at higher temperatures. Only mix the quantity required for the job.

**Retarder (Ultra Slow) Thinner:** In hot or draughty conditions Mirotone recommends that no more than 10% Ultra Slow Thinners is added. Exceeding this amount may retard the drying and could lead to problems with sanding, printing and blocking. Use faster thinners to achieve required viscosity and then use (only if required) a small amount of Ultra Slow Thinner to improve flow and levelling.

**Recommended MIROSOL® Thinners****Thinner Rating Guide**

••• Highly Recommended      •• Recommended      • Approved

Speed of Dry (Listed Fastest to slowest)	Suitability	MIROSOL Thinner	Aromatic Free?	Pack Size Available			
				4 Litre	20 Litre	60 Litre	205 Litre
Ultra Fast	••	MIROSOL 1234	Yes		*	*	
Fast	•••	MIROSOL 1280	No		*	*	
	•••	MIROSOL 1232	Yes	*	*	*	
	•••	MIROSOL 1217	Yes	*	*		
Medium	••	MIROSOL 1231	No		*		
	••	MIROSOL 1269	No	*	*		
	•••	MIROSOL 1263	No	*	*	*	
	••	MIROSOL 1265	Yes	*	*	*	
Slow	•••	MIROSOL 1266	Yes	*	*	*	
	••	MIROSOL 1260	Yes	*	*	*	
Ultra Slow	•••	MIROSOL 1218	No	*	*	*	
Specialty Reducers	•	MIROSOL 1281 Matt Promoter for PU 5555 & 5650	No	*	*		

**Application Viscosity & Wet Film Thickness**

Spray only in properly constructed and compliant spray booth.

**Spraying Viscosity:** 20-30 seconds BS4 Flow Cup at 25°C.

**Wet Film Thickness:** 150-200 microns wet film thickness per coat.

**Approximate Drying Times @ 20°C**

**Dust Free:** 10-20 minutes

**Touch Dry:** 30-40 minutes

**Sanding:** 3 hours

**Hard Dry:** 4-6 hours

**Block Stacking:** 24 hours



**Note:** Stated temperatures are dependent on your choice of hardener and thinners. Temperatures below 16°C and the use of Slow or Ultra Slow thinners will retard the drying time.

<b>Full Cure:</b>	7 days																																																																															
<b>Force Drying Procedure</b>																																																																																
<b>Flash Off:</b>	5-10 minutes @ 20°C																																																																															
<b>Force Dry:</b>	30 - 60 minutes @ 40-50°C (dependent on airflow)																																																																															
<b>Cool Down:</b>	10 minutes @ 20°C																																																																															
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MIROTHANE PU 5600 Pigmented Undercoat has a 12 month shelf life when stored in sealed containers below 25°C.																																																																																
<b>Coverage (theoretical)</b>																																																																																
6-7 m <sup>2</sup> per litre at 100% transfer rate when applied with a conventional spray gun at 150 micron wet film build applied at 25 seconds BS4 application viscosity. These measurements are dependent on the application equipment / gun set-up and the articles being coated. <b>Note:</b> The above coverage is the maximum rate possible and will vary dependent on the application equipment set up and total wastage.																																																																																
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All wood and wood related substrates must be free from dust, grease, dirt and all other contaminants before proceeding. Contaminants may be removed by washing the substrate with MIROSOL 1231 Medium Thinner which is ideal for removing wax and grease. Fill all wood defects with MIROPUTTY 916 water based wood filler (i.e. cracks, holes, etc) or fill open grain woods with MIROFIL 1702, if full high build finish is required.																																																																																
<b>Sanding</b>																																																																																
Wood Substrates - Sand to a smooth even finish using 180-240 grit 3M Production Fre-cut paper. MDF Boards - Sand to a smooth even finish using 240-320 grit 3M Production Fre-cut paper. Remove all sanding dust using an air gun and clean lint free cloths.																																																																																
<b>Undercoating</b>																																																																																
Undercoat substrate with MIROTHANE PU 5600 as per instructions on this data sheet. Undercoating MDF: When undercoating raw MDF MIROLOK SB 3511 is recommended to reduce problems associated with wax extraction and stress cracking on routed components and edges. Apply one light coat then allow a 10 minute interval before sanding with 320 grit fre-cut paper to remove any raised fibres from the MDF. Sand MIROLOK SB 3511 to a smooth finish and apply MIROTHANE PU 5600 in even coats to achieve the desired film build, maximum total wet film thickness 175-200 WFT per coat.																																																																																
<b>Sanding:</b> Allow to dry for 3 hours depending on ambient temperature and wet film build. To ensure the best adhesion between topcoat and undercoat, sand the undercoat immediately prior to top coating. For subdued gloss finishes, sand with 280-320 grit Fre-Cut paper. For high gloss finishes, use 400-500 grit Free-Cut paper. Remove all sanding dust using an air gun and clean lint free cloths.																																																																																
<b>Note:</b> Do not leave sanded undercoated panels for long periods before topcoating as the adhesion of the topcoat to the polyurethane may be reduced. All sanded panels should be topcoated the same day. For best topcoat hold up overnight dry before sanding is recommended.																																																																																
<b>Topcoat</b>																																																																																
MIROTHANE PU 5600 may be topcoated with:																																																																																
<ul style="list-style-type: none"> <li>• <a href="#">MIROTHANE PU 5650 Pigmented Topcoat</a></li> <li>• <a href="#">MIROTHANE PU 5605 Pigmented Topcoat</a></li> <li>• <a href="#">MIROTHANE PU 5608 Pigmented Topcoat</a></li> <li>• <a href="#">MIROTHANE PU 5666 Pigmented Topcoat</a></li> <li>• <a href="#">MIROBILD AC 3750 Pigmented Topcoat</a></li> </ul>																																																																																
Apply as per instructions on the relevant product data sheet.																																																																																
If sanding between coats, allow 1-2 hours to dry and then sand with 400-500 grit Fre-Cut paper.																																																																																

Remove all sanding dust using an air gun and clean lint free cloths.  
Apply a second coat of topcoat.

### Tinted Undercoat

MIROTHANE PU 5600 undercoat can be purchased in one of the following colours below:

- 2060 Light Grey
- 5071 Pastel Yellow
- 7024 Rusty Pink
- 8049 Sky Blue
- 9041 Pale Green
- 0001 White

To create your own tinted undercoat is it possible to add left over MIROTHANE PU 5650 topcoat into MIROTHANE PU 5600 undercoat as the following addition rate (amount below make one litre of coloured undercoat):

MIROTHANE PU 5600 White Undercoat	MIROTHANE PU 5650 Pigmented Topcoat	MIROTHANE PU 5747 or 5780 Hardener	Thinner amount
70% = 700mls	30% = 300mls	500mls	15% : 225mls

### Warnings

**!** **Follow Directions:** Carefully read the contents of this Data Sheet and the associated Material Safety Data Sheet (MSDS). Please do not apply this product unless:

- You have a Material Safety Data Sheet (MSDS) in your possession.
- You fully understand these important documents, and
- You are prepared to follow all directions.

**!** **Not Recommended:** This product is not recommended for the following applications:

- Exterior exposure
- Wear surfaces on flooring

**!** **Harsh In-Service Environments:** For harsh in-service environments Mirotone recommends the use of MIROTHANE PU 5545 Clear sealer with MIROTHANE PU 5555 Clear topcoat or MIROTHANE PU 5625 or MIROPOL PE 5110 & 5111 pigmented undercoat with MIROTHANE PU 5650 or 5605 pigmented topcoat.

**!** **Damage caused by sharp objects:** Coatings can be damaged by sharp objects. Due care should be taken in harsh in-service environments to protect the coating e.g. use placemats, coasters, table cloths or other protective coverings.

**!** **Recommended Coating System:** For superior coating properties and in-service performance, Mirotone recommends the application of one sealer coat followed by two coats of an approved topcoat. Alternatively for high volume production environments a two sealer / one topcoat system may be used but this will lead to reduced physical properties of the coating system. In clear coating systems excessive application of sealer or topcoat may result in milky or cloudy appearance in the final finish.

**!** **MIROSOL Thinners:** The use of any thinner other than the approved list on this data sheet will void any warranty that Mirotone may offer. Refer to Mirotone's Technical Bulletin "Mixed Coating Systems".

**!** **High Humidity and Moisture In-Service Environments:** All wood will swell and discolour if allowed to come into contact with water vapour. The protection provided by a coating is dependent on the moisture transmission of the coating and on the thickness of the dry coating film applied. Coated sharp edges are usually the most vulnerable to damage either from the coating being removed or by inadequate film builds in high wear / traffic areas. Special care during sanding and coating should always be given to sharp edges as the coatings do not build as well onto them, resulting in reduced protection in high moisture environments.

**!** **Damp Wood:** Do not apply coatings over damp wood (moisture content greater than 15%) as the following may result:

- Loss of adhesion to the wood
- Cracking or veneer checking of the wood
- Frying of the coating system, particularly with Acid Catalysed systems

**!** **High Humidity at Time of Application:** Application of coatings at high humidity will:

- Speed up the drying process and reduce the pot life of polyurethane coatings.
- Increase the risk of blooming (whitening).
- Blooming may occur if the coating is applied over damp wood or exposed to water or dew during the first hour of drying.

**!** **Milkiness:** Coating systems using multiple coats of any sealer will increase the risk of the dry film appearing milky (especially when applied over dark stains or woods) and may result in white marking if the film is damaged by sharp objects.

**!** **White Marking:** If damaged by sharp objects, MIROTHANE PU 5555 may show white marking when applied over MIROPOL PE 5010 clear sealer and should therefore not be used in high traffic environments.

**!** **Cold Temperature:** Application of any coating at low temperatures will reduce the general in-service performance of the coating due to reduced cross linking of the coating. Application of MIROTHANE PU or MIROPOL PE below 15°C and MIROCAT PC or MIROBILD AC below 10°C may affect drying and the gloss level of the coating.

**!** **Inter-coat Adhesion:** To ensure sound inter-coat adhesion, thoroughly sand between coats. To reduce the potential for adhesion failure in the field, Mirotone strongly recommends it's customers carry out regular and appropriate quality control testing of their production output.

**!** **Bridging:** On routed MDF panels and doors DO NOT exceed the recommended wet film thickness, as cracking or bridging of the dry film in the grooves may occur.

**!** **Handling:** The transfer of oils or fats from the skin to the surface of the coating may leave visible finger prints on dry coatings. The lower the gloss level and the darker the colour the more visible the finger prints will be. Therefore use of dark low gloss colours should be carefully considered. In most cases Mirotone's Sprayglow will remove finger prints.

**!** **Packaging:** Any two component coating mixed with a slow hardener or retarder thinner will require increased drying time before packaging. The same Part B must be used on the entire job to ensure a visually consistent finish.

## Health & Safety

Refer to Material Safety Data Sheet (MSDS). MSDS sheets are available at [www.mirotone.com](http://www.mirotone.com)

**Ensure that all Personnel using this product have read and understood this data sheet and the associated MSDS and packaging label before using this product.**

**Engineering Controls:** Avoid inhalation of vapour or sanding dust by maintaining adequate ventilation. Avoid pockets of vapour. This is normally achieved by applying in a well-exhausted spray or sanding booth complying with AS 4114. If inhalation risk exists (e.g. spraying) the operator must wear an air supplied positive pressure demand full-face mask complying with AS1716 and use in accordance with AS1715.

**Personal Protection:** Contact with any chemical should be avoided. Avoid contact with skin and eyes, and avoid breathing the vapour or spray mist. Wear suitable protective clothing including rubber or PVC gloves and safety goggles. When using, do not eat nor smoke.

## Mirotone Accreditations

**Research Laboratory:** Mirotone's head office research laboratory in Sydney, Australia holds N.A.T.A. accreditation No. 865 under ISO/IEC 17025:1999 General Requirements for the Competence of Testing and Calibration Laboratories.  
N.A.T.A. - National Association of Testing Authorities

**Quality System:** Mirotone is N.A.T.A. certified to AS/NZS ISO 9001:2000 Quality Systems for design and manufacturing.

## Mixed System Policy

### A Mixed System is:

Where any coating or additive manufactured by another coating manufacturer is applied under, between, in, or on top of, coatings manufactured by Mirotone. [Additives may include thinners, retarding solvents, hardeners, flow additives, stains or catalysts]; or

Where products manufactured or supplied by Mirotone are used in a manner not approved or recommended by Mirotone on its labels or Data Sheets.

**Policy:** Mirotone will not recognise any warranty claim from customers or third parties if any Mirotone product has been used in a Mixed System. Mirotone can only warrant the quality of its own range of coatings when used in strict accordance with the recommended coating systems thinners and additives stated on Mirotone's labels and Data Sheets.

## Limitation of Liability

**This Data Sheet is based on information in Mirotone's possession at the "Date of Issue" above. Later experience may lead to amendments. Users should check with Mirotone to ensure that this Data Sheet is still current.**

The information contained in this Data Sheet is based on data appraised in our Laboratories and on our own research, and that of others whose work we believe is reliable. Due to possible differences between controlled laboratory test conditions and methods, and actual application conditions and methods, coupled with possible differences in interpretation of results, the user of this product must satisfy himself that the end result obtainable under his particular application conditions meets his requirements. Special attention is directed to the problem of chemical compatibility, as Mirotone can control only the quality and formulation of its own materials. Mirotone has no control over quality, formulation or consistency of other manufacturers' products or the substrate to which its product is applied. Therefore Mirotone supplies its products only on condition that the consumer himself is satisfied as to the performance of the product in meeting his particular requirements.

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